

Work Order ID 68078

Wednesday, April 06, 2011 10:05:29 AM



Page 1

Item ID: D3874-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3874	A								

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x2

OK

11/04/12

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240° FTime IN: 4:00 pmTime OUT: 2:00 am11/04/11
11/04/12

x2

OK

11/04/12

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Page 2

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Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 Thermoform Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA039 using tool DT9474 Dwg Rev: <u>A</u> Folio Rev: <u>B</u>	0.00 0.00				<u>x2</u>			<u>He</u> 11/04/12
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect part for proper formation and texture	0.00 0.00				<u>x2</u>			<u>He</u> 11/04/12
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>W</u>	<u>11</u>	<u>04</u>	<u>12</u> (2)

Work Order ID 68078

Page 3

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Item ID: D3874-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandThermo	Memo	0.00				2			DL 11/04/19
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150 QC	QC2- Inspect parts off machine FAI/FAIB	0.00				12			DL 11/04/20
Quality Control	Memo Complete FAI document	0.00							
160 QC	QC5- Inspect part completeness to step on W/O	0.00				2			DL 11/04/28
Quality Control	Memo	0.00							

Work Order ID 68078

Page 4

Wednesday, April 06, 2011 10:05:29 AM

Item ID: D3874-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/4/285/20

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/297/20

11-09-28/20

Picklist Print

Wednesday, April 06, 2011 10:05:26 AM

Page 1

Work Order ID: 68078

Parent Item: D3874-2

Parent Item Name: Floor Protector



Start Date: 4/5/2011

Required Date: 4/6/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.118-90318-08

Purchased

No

100

sf

2,333.910

4.38

8.76



Lexan Sheet

Location

Loc Qty

Loc Code

therm

2333.91

2333.91

113127

8.7658 St

DL
11/04/20

DART AEROSPACE LTD		Work Order: 68078
Description: Floor Protector		Part Number: D3874-2
Inspection Dwg: D3874	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL Date: 11/04/20

TRIMMING SECTION

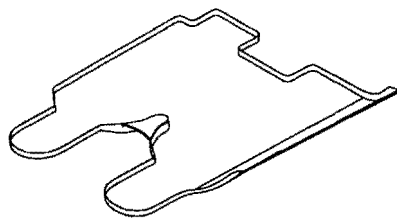
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.058"	✓		Visual CX-CO	
0.065	Min	0.085"	✓		CAL TH-OT	
0.5	Min	0.58"	✓		Visual CX-CO	
21.9	REF	21.95"	✓		TAPE PL-CI	

Measured by: DL Date: 11/04/20

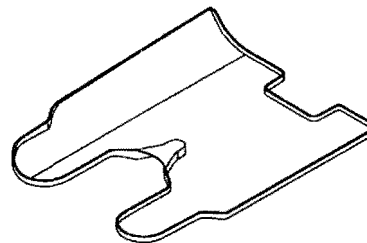
Audited by: JB Date: 11/04/27

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>DL</u>



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

68078

RELEASED
29/05/05

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3874	SHEET 1 OF 3
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	FLOOR PROTECTOR	NTS
DATE	09.01.29	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

C

B

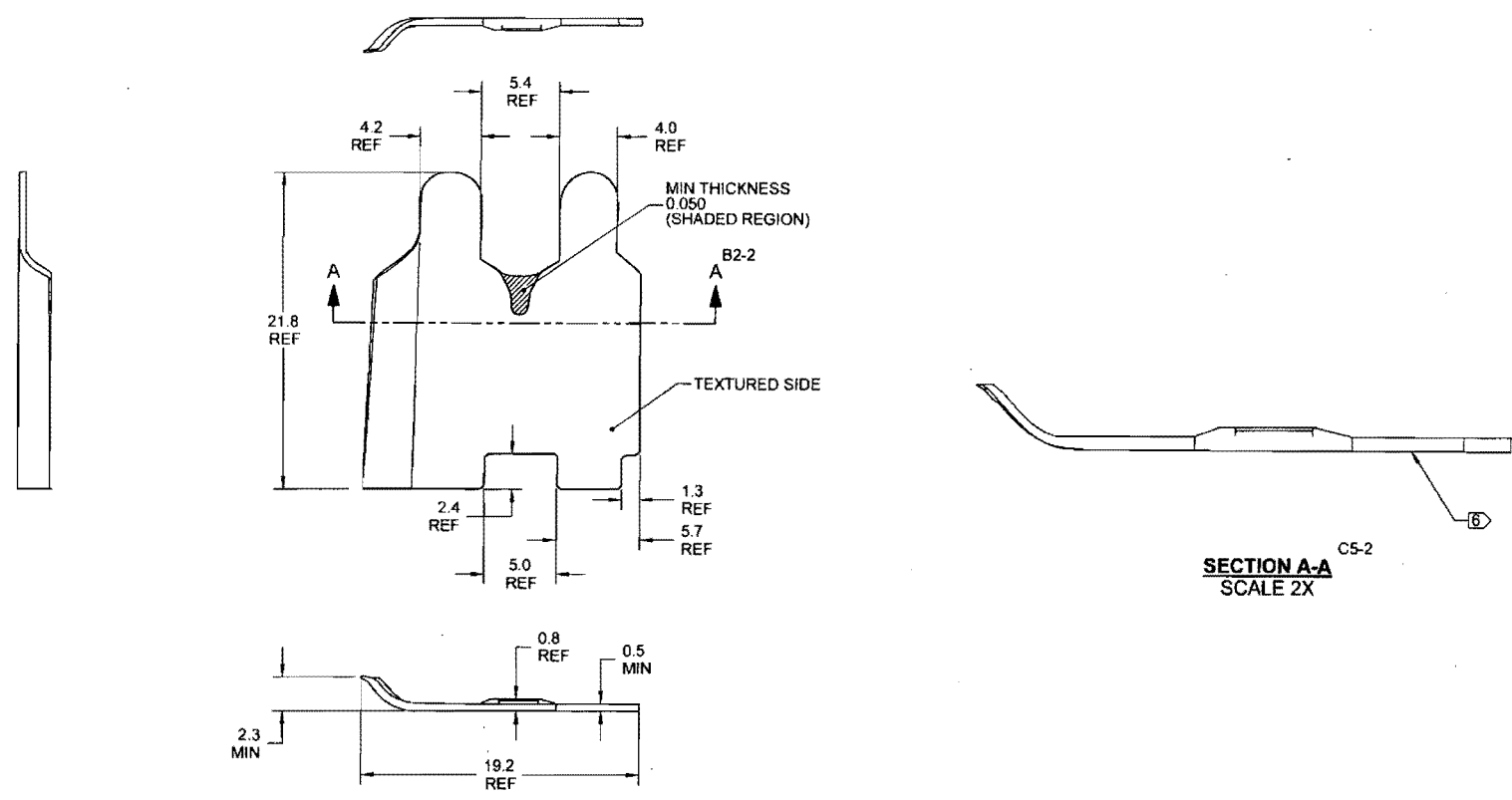
A

D

C

B

A



D3874-1 FLOOR PROTECTOR

SECTION A-A
SCALE 2X

RELEASED
9/25/2014

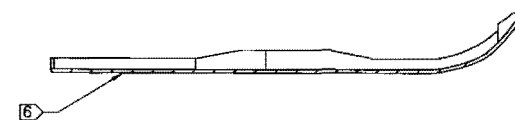
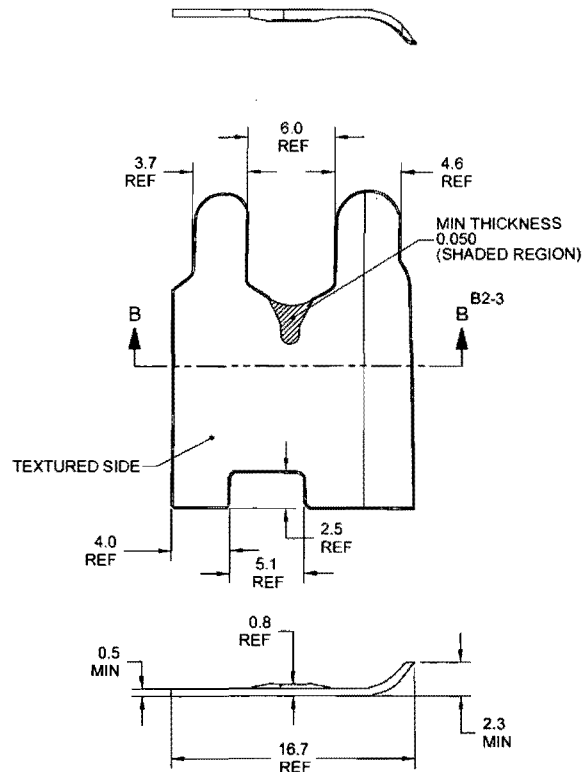
NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

68078

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG APPR.	<i>PH</i>	D3874	SHEET 2 OF 3
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	FLOOR PROTECTOR	NTS
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8 7 6 5 4 3 2 1



SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

RELEASED
9/25/05

DESIGN	PA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	PA			
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3874	SHEET 3 OF 3
APPROVED			TITLE	SCALE
DE APPR.			FLOOR PROTECTOR	NTS
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